

Work Order ID 117257

117257

Page 1

Thursday, May 01, 2014 10:28:10 AM

Item ID: D119-646-211 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube with Run-On Landing Wearplates LH
 Start Date: 4/25/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/25/14 Req'd Qty: 1.00 *1* Customer:
 Reference: REWORK -NCR14-3771

Approvals: Process Plan: *AA* Date: 14-05-01 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D119-646	B

100 Document Control

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile & type labels per PPP D119-646-211
 CHG004

101

101

HandFinish

Hand Finishing

Memo

REMOVE FWD & AFT CAPS D2855-3

CLEAN ALL SIKAFLEX OFF CAPS & *scrip*

IDENTIFY PER EACH TUBE CAPS

WAS REMOVED (PN & B)

wear plates - keep with B/A
 AS PAR ECN RS1015 *scrip hardware*

PULL FROM STOCK:

1 X D119-646-211 B113481

REWORK PER NCR14-3771

PART		US #5735484 / CA #2222184 / EURO #0828655	
PN	D119-646-211	CHG	CHG004
DESC	Skidtube STD, LH	STC	SR02024SE
LOT	B113481	STC	
MODEL	Agusta A119/AW119MKII	STC	
TC APPROVAL #0938		MADE IN CANADA	

14-9-16

P/O: 26625

Imt

CY 14/11/26 ①

Receive 1x SP14-12-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 117257

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Item ID: D119-646-211 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube with Run-On Landing Wearplates LH
Start Date: 4/25/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/25/14 Req'd Qty: 1.00 ***1*** Customer:
Reference: REWORK -NCR14-3771

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
102		0.00							
102									
Skidtubes	Memo	0.00				1	0	BE	14-09-16
Skidtubes	DRILL OUT & REMOVE FWD CROSS BOLT SPACERS D2579 IN DETAIL C ON DWG D3887								
103		0.00							
103									
Skidtubes	Memo	0.00				1	0	BE	14-09-25
Skidtubes	REPOSITION LOCATION OD HOLES AS PER DWG BUT USING +/- 0.005" TOL AND PER SYMMETRICAL IN QSI 018								
104		0.00							
104									
Skidtubes	Memo	0.00				1	0	BE	14-09-25
Skidtubes	TACK ONLY CROSS BOLT SPACER D2579 B: 123997 x2								

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Skidtube with Run-On Landing Wearplates LH

Start Date: 4/25/14 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 4/25/14 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference: REWORK -NCR14-3771

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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105

0.00

105

QC

Quality Control

Memo

0.00

LOCATION MUST BE VERIFIED BY OC RECORD DIMS HERE

DAS

2

9-89

106

0.00

106

Skidtubes

Skidtubes

Memo

0.00

WELD AS PER QSI 004 A/R M/29399
BACK DRILL
GRIND WELDS FLUSH & DEBURR

107

QC10- Inspect visual per QSI004- ground welds	0.00
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107

QC

Quality Control

Memo

0.00

QC 10 & 5 INSPECTION
TEST FIT 6HW WHEELS

PASS: ✓

1

1

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Item ID: D119-646-211 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube with Run-On Landing Wearplates LH
 Start Date: 4/25/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/25/14 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
108		0.00							
108									
HandFinish	Memo	0.00							
Hand Finishing	TOUCH UP ALODINE AS PER QSI 005								15-2-20 DSC
109		0.00							
109									
HandFinish	Memo	0.00							
Hand Finishing	TOUCH UP POWDERCOAT AS PER QSI 005								START: 10:20 OVEN T: 320° FINISH: 10:50
111		0.00							
111									
HandFinish	Memo	0.00							
Hand Finishing	RE-ASSEMBLE ORIGINAL CAPS BACK ON TUBES								1 x d 15/04/16
	SIKAFLEX: 11131570								
	EXP: 1-16								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Material									
Operator									
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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Work Order ID 117257

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117257

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Item ID: D119-646-211 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 4/25/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/25/14 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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112	QC3- Inspect Part Finish	0.00							
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112

QC

Quality Control

Memo

0.00

① 15-04-27

DAS
9
9-89

113	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

113

QC

Quality Control

Memo

0.00

① 15-04-27

DAS
9
9-89

114		0.00							
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114

Packaging

Packaging

ped new kits

Memo

MAKE SUR ORIGINAL KIT IS IN THE BOX

0.00

took kit for shipment w 14.09.15

REPACKAGE USING NEW BACHT NUMBER.ADD NEW LABELS AS REQUIRED

DAS
96
9-89

APR 27 2015

02 02 15

QC4

DAS
96
9-89

APR 27 2015

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

Work Order ID 117257

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Item ID: D119-646-211

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube with Run-On Landing Wearplates LH

Start Date: 4/25/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/25/14 Req'd Qty: 1.00 ***1***

Customer:

Reference: REWORK -NCR14-3771

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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116

QC21- Final Inspection - Work Order Release

0.00

116

QC

Memo

0.00

Quality Control

MLJ 1504-28

MLJ 1504-28

PARTS NO:	Batch no:	QTY:
D3849-041	B120888	X1
D3849-043	B118842	X1
D3904-1	B125626	X16
AN3C-46A	M131367	X8
AN3C-5A	M131320	X2
D3672-1	B113581	X2
MS24694-C52	M127059	X2
MS21043-3	M136673	X8
D2855-3	B111848	X2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
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Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY									
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube		General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function		☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge _____ _____ _____		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____	

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Page 1

Work Order ID: 117257

117257

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube with Run-On Landing Wearplates LH

Start Date: 4/25/14

Required Date: 4/25/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
12.09.12 as per ECN12-644 DD verf:JLM IPP Rev:B
raise to chg003 (ECN 12-675) DD verf:JLM IPP REV:C 12.11.05
chg004 (ECN 13-534) DD verf:JLM IPP REV:D 13.03.20 raise to

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-211		Manufactured	No				Each	0.0000		1			

D119-646-211

Skidtube with Run-On Landing Wearplates LH

**

15.5.6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 117257

117257

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 4/25/14

Required Date: 4/25/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
12.09.12 as per ECN12-644 DD verf:JLM IPP REV:C 12.11.05
raise to chg003 (ECN 12-675) DD verf:JLM IPP REV:D 13.03.20 raise to
chg004 (ECN 13-534) DD verf:JLM IPP REV:E 14.11.25 IIN REV.C (ECN
14-628) DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C50A		Purchased		No			Each	116.0000		8			
AN3C50A									**			DAS 27 9-89	
Bolt													
					<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				
					ST338a			48					
					131651			24					
					M131367			24					
					ST346			68					
					M128491			16					
					<u>M131263</u>			28		5			
					M131856			24					
AN4C6A		Purchased		No			Each	586.0000		12			
AN4C6A									**			DAS 27 9-89	
Bolt													
					<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				
					FG			14					
					103344			4					
					121657			10					
					ST312A			320					
					<u>m131320</u>			20		12			
					m131618			300					
					ST345			252					
					m130716			52					
					m131410			200					

17 new

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Page 2

Work Order ID: 117257

117257

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 4/25/14

Required Date: 4/25/14

Start Qty: 1.00

Required Qty: 1.00

D119-646-311

Manufactured No

Each 6.0000 1

D119-646-311

Ground Handling

DAS

27

~~9-89~~

DAS

~~06~~

~~9-89~~

Location

Loc Qty

Loc Code

PK013

3

124440

3

PK13

3

124441

3

Each 552.0000 16

D2652

Manufactured No

D2652

Bushing

DAS

27

~~9-89~~

DAS

~~06~~

~~9-89~~

Location

Loc Qty

Loc Code

FG

45

31985

45

ST009

68

129992

68

ST012a

439

123711

32

124422

3

129992

0

129993

301

131087

103

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

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Page 3

Work Order ID: 117257

117257

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 4/25/14

Required Date: 4/25/14

Start Qty: 1.00

Required Qty: 1.00

D2712

Manufactured No

Each

620.0000

12

D2712

Set Screw

DAS
27
9-89

DAS
86
9-89

Location

Loc Qty

Loc Code

FG	55	
29962	55	
ST009	115	
115155	113	12
121858	2	
ST012a	450	
127910	250	
130024	200	

D3407-041

Manufactured No

Each

6.0000

1

D3407-041

Tow Ring

DAS
27
9-89

DAS
86
9-89

Location

Loc Qty

Loc Code

ST532	6	
107840	3	
116785	1	1
119184	2	

D3417-5

Manufactured No

Each

125.0000

D3417-5

Washer

DAS
27
9-89

DAS
86
9-89

Location

Loc Qty

Loc Code

ST038	41	
124382	1	
128483	40	
ST038A	84	
119575	2	
129948	40	
131054	42	

17 Mass

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Design ☐	Operator ☐																																																																			
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Picklist Print

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Work Order ID: 117257

117257

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 4/25/14

Required Date: 4/25/14

Start Qty: 1.00

Required Qty: 1.00

D3417-7

Manufactured No

Each

61.0000

1

D3417-7

Washer

~~DAS
27
9-89~~

N/A

Location

Loc Qty

Loc Code

ST038

37

102368

37

ST038A

24

124178

24

D3456-1

Manufactured No

Each

110.0000

1

D3456-1

Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST051A

103

121045

1

128456

3

129861

49

130974

50

~~DAS
26
9-89~~

~~DAS
27
9-89~~

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

Wednesday, April 22, 2015 10:59:38 AM

Page 5

Work Order ID: 117257

117257

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 4/25/14

Required Date: 4/25/14

Start Qty: 1.00

Required Qty: 1.00

D3672-3

Manufactured No

Each

642.0000

24

D3672-3

DAS 27 9-89

Washer, Phenolic

DAS
86
9-89

Location

Loc Qty

Loc Code

FG

153

127875

50

129916

40

84432

11

89273

52

FP001

14

107316

14

ST055

475

121577

40

129916

435

24

D3672-7

Manufactured No

Each

680.0000

24

D3672-7

DAS 27 9-89

Washer, Phenolic

DAS
86
9-89

Location

Loc Qty

Loc Code

FG

45

124419

36

93370

9

ST055

49

120476

49

ST064A

586

124419

86

129987

500

24

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

Picklist Print

Wednesday, April 22, 2015 10:59:38 AM

Page 6

Work Order ID: 117257

117257

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 4/25/14

Required Date: 4/25/14

Start Qty: 1.00

Required Qty: 1.00

D3883-1

Manufactured No

Each

6.0000

2

D3883-1

DAS

Saddle, Outboard LH

27

9-89

Location

Loc Qty

Loc Code

ST404

6

124452

2

128747

2

129416

2

DAS

86

9-89

D3884-1

Manufactured No

Each

3.0000

2

D3884-1

Saddle, Inboard LH

DAS

27

9-89

Location

Loc Qty

Loc Code

ST404

3

125107

2

128748

1

DAS

86

9-89

MS21043-3

Purchased No

Each

990.0000

8

MS21043-3

Nut

DAS

27

9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

78

m130673

78

GA

367

m130673

15

m131677

352

ST304

465

m131340

465

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Wednesday, April 22, 2015 10:59:38 AM

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Work Order ID: 117257

117257

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 4/25/14

Required Date: 4/25/14

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

Each

1,096.000

13

DAS

27

~~9-89~~

MS21043-4

Nut

DAS

~~06~~

~~9-89~~

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

383

m128798

383

ST304

673

m128818

34

m131697

639

13

MS21250-05-006

Purchased

No

Each

89.0000

8

DAS

27

~~9-89~~

MS21250-05-006

BOLT

DAS

~~06~~

~~9-89~~

Location

Loc Qty

Loc Code

FG

10

124291

10

ST273A

74

M131379

30

M131620

44

ST298

5

M129795

5

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																	
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

Picklist Print

Wednesday, April 22, 2015 10:59:38 AM

Page 8

Work Order ID: 117257

117257

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 4/25/14

Required Date: 4/25/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

Each

4,356.000

8

DAS
27
~~9-89~~

✓ ***NAS1149C0332R***
WASHER

DAS
86
9-89

Location

Loc Qty

Loc Code

FP001

2174

123248

34

m130325

2140

GA

734

m131618

734

ST260a

1424

m131697

1424

ST271

24

m131340

24

8

NAS1149C0432R

Purchased

No

Each

3,575.000

24

DAS
27
~~9-89~~

✓ ***NAS1149C0432R***
WASHER

DAS
86
9-89

Location

Loc Qty

Loc Code

GA

2238

m125807

476

m131467

1762

ST271

1337

m131452

1337

24

NAS1149C0532R

Purchased

No

Each

389.0000

8

DAS
27
~~9-89~~

✓ ***NAS1149C0532R***
WASHER

DAS
86
9-89

Location

Loc Qty

Loc Code

GA

62

116513

62

ST271

327

m128537

127

m131624

200

8

Wednesday, April 22, 2015 10:59:38 AM

Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Status	Item ID	Rev	Name	Start Date	Qty	JO	MP	De	Scrap	Qu	Un	Me	N	C	II	Sort	Off	T	Per	h	to
	AN3C50A ✓		Bolt	8/21/09	8	Ea		11	0	0						6	0	M	☐	☐	
	AN4C6A ✓		Bolt	8/21/09	12	Ea		11	0	0						7	0	M	☐	☐	
	D119-646-241		Replacement Skidtube with Run-On W...	12/05/09	1	Ea		11	0	0						1	0	M	☐	☐	
	D119-646-311 ✓		Ground Handling	12/05/09	1	Ea		11	0	0						2	0	M	☐	☐	
	D2652 ✓		Bushing	12/05/09	16	Ea		11	0	0						5	0	M	☐	☐	
	D2712 ✓		Set Screw	12/05/09	12	Ea		11	0	0						14	0	M	☐	☐	
	D3407-041 ✓		Tow Ring	12/05/09	1	Ea		11	0	0						17	0	M	☐	☐	
	D3417-5 ✓		Washer	12/05/09	1	Ea		11	0	0						18	0	M	☐	☐	
	D3417-7		Washer	12/05/09	1	Ea		11	0	0						20	0	M	☐	☐	
	D3456-1 ✓		Washer	12/05/09	1	Ea		11	0	0						19	0	M	☐	☐	
	D3672-3 ✓		Washer, Phenolic	12/05/09	24	Ea		11	0	0						16	0	M	☐	☐	
	D3672-7 ✓		Washer, Phenolic	12/05/09	24	Ea		11	0	0						15	0	M	☐	☐	
	D3883-1 ✓		Saddle, Outboard LH	12/05/09	2	Ea		11	0	0						3	0	M	☐	☐	
	D3884-1 ✓		Saddle, Inboard LH	12/05/09	2	Ea		11	0	0						4	0	M	☐	☐	
	MS21043-3 ✓		Nut	8/21/09	8	Ea		11	0	0						12	0	M	☐	☐	
	MS21043-4 ✓		Nut	8/21/09	13	Ea		11	0	0						13	0	M	☐	☐	
	MS21250-05-006 ✓		BOLT	8/21/09	8	Ea		11	0	0						8	0	M	☐	☐	
	NAS1149C0332R ✓		WASHER	10/03/13	8	Ea		11	0	0						9	0	M	☐	☐	
	NAS1149C0432R ✓		WASHER	10/03/13	24	Ea		11	0	0						10	0	M	☐	☐	
	NAS1149C0532R ✓		WASHER	10/03/13	8	Ea		11	0	0						11	0	M	☐	☐	

DART AEROSPACE LTD		Work Order:	
Description: Repair Scheme D119-646-241 Skid tubes FWD GHW holes do not align NCR 14-3771 For tubes in production and Returned tubes			
Drawing: D3887	Repair Scheme:	RS1015	
Part No: D119-646-241	Page:	1 of 1	
Batch No:	Qty:	1	

Step	Location	Procedure	By	Date	Qty
1	Finishing	Remove FWD & AFT caps D2855-3. Clean all sikaflex off cap & identify per each tube caps was removed (P/N & B#)	BE	14-09-24	1
2	Skidtube	Drill out & remove FWD Cross bolt spacers D2579 in Detail C on Dwg D3887	BE	14-09-24	1
3	Skidtube	Reposition location of holes as per Drawing but using <u>+/-0.005" tol</u> and per symmetrical in QSI 018	BE	14-09-24	1
4	Skidtube	TACK ONLY Cross bolt spacers D2579 B <u>123997</u> x 2	BE	14-09-24	
5	QC	Location MUST be verified by QC Record Dims HERE <i>check with jig</i>	DAS 9 9-89	14-09-24	①
6	Skidtube	Weld as per QSI 004 A/R <u>1122399</u> x 2 Back Drill Grind welds flush & deburr	BE	14-09-25	①
7	QC	QC 10 & 5 Inspection ***TEST FIT GHW WHEELS*** Pass ☐	DAS 9 9-89	14-09-25	
8	Finishing	Touch up alodine as per QSI 005	DSC	15-2-20	①
9	Finishing	Touch up Powder coat per QSI 005	DAS 9 9-89	15-4-15	8
10	Finishing	Re-assemble original caps back on tubes Sikaflex B _____ exp _____			
11	QC	QC 3 inspect	DAS 9 9-89	15-4-27	
12	QC	QC 5 inspect	DAS 9 9-89	15-4-27	
13	QC	QC21			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.04.29	New Issue	ED		

U:\Admin\Forms\Repairschemb1A.doc

Rev. A

Linda Lacelle

From: David Shepherd
Sent: May-04-14 12:21 PM
To: Patrick Smith; Kim Johnston
Cc: Bill Beckett; Nigel Forbes; Linda Lacelle; Mike Petsche; Marc Bellavance; Sian Willems
Subject: RE: RS1015-RevA
Attachments: RS1015-RevA.DOC

Pat,

Sorry for the slow reply. Busy week.

My recommendation is for you to bring the tubes in and double check the fit of the wheels.

If the fit is OK, then you are done.

If the fit is not OK and you can move the holes by 0.030" to get them to fit, you can do the attached repair.

If the holes are out by more than 0.030", then the tube is scrap.

I recall that some of the holes were off by up to 3/16".

We should NOT be welding crossbolt spacers into huge slots that we backfill with weld.

Regards,
David

From: Patrick Smith
Sent: April-29-14 7:00 AM
To: Kim Johnston
Cc: David Shepherd
Subject: RS1015-RevA

Hi Kim,

We required a new RA for repairing the AW119 Skid Tubes, Eric prepared it and I reviewed it.

David,

Could you please review, this is for the problem with the AW119 Skidtubes,



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26625**

Purchase Order Date 11/26/2014

PO Print Date 11/26/2014

Page Number 1 of 3

Order From :

VC-IMI001

Ship To : DART AEROSPACE LTD

IMI MANUFACTURING INC.
772 MAIN ST. E.P.O. BOX 3
HAWKESBURY, ON K6A 2R4
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FA-10

Contact Name

Vendor Phone 613 675 1208 Ext.223

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	117257 SKIDTUBE TO BE STRIP WITH STRIPPER P/N: KSGAR343 FROM BERTRAND SUPPLIES	D119-646-211 SKIDTUBE	12/19/2014 Yes 12/19/2014		1.00 ✓	\$412.50	\$412.50
Line Total:							\$412.50
2	117258 SAME AS ABOVE	D119-646-211 SKIDTUBE	12/19/2014 Yes 12/19/2014		1.00	\$412.50	\$412.50
Line Total:							\$412.50
3	118472 SAME AS ABOVE	D119-646.241 SKIDTUBE	12/19/2014 Yes 12/19/2014		1.00	\$412.50	\$412.50

SP14-12-8

PO Instructions: PROCUREMENT QUALITY CLAUSES
A000 CLAUSES NOT REQUIRED

Note:

11/26/2014



Manufacturing Inc.

2056 County Rd #4, L'Original, Ontario K0b 1K0

Phone 613-675-1208

Fax 613-675-1250

PACKING SLIP

TO: Dart Aerospace Ltd

1270 Aberdeen Street

Hawkesbury, On K6A 1K7

Date: December 8/2014

SALESPERSON	JOB	PO NUMBER	NOTE
	14-0574-22	26625	

QTY ORDER	DESCRIPTION	QTY SHIP	LINE TOTAL
1	Skidtubes to be Strip with Stripper <i>SP14-12-8</i>	1	

Client: (PRINT NAME) _____ (SIGNATURE) _____

THANK YOU FOR YOUR BUSINESS!

6.0 PARTS LIST

6.1 Standard Skidtubes

Item	Qty -011	Qty -012	Qty -111	Qty -112	Qty -211	Qty -212	Qty -041	Qty -141	Qty -151	Qty -241	Qty -251	Qty -311	Part Number	Description
	X												D119-646-011	STANDARD SKIDTUBE INSTALLATION WITH WEARPADS, LH
		X											D119-646-012	STANDARD SKIDTUBE INSTALLATION WITH WEARPADS, RH
			X										D119-646-111	STANDARD SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, LH
				X									D119-646-112	STANDARD SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, RH
					X								D119-646-211	STANDARD SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, LH
						X							D119-646-212	STANDARD SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, RH
	1	1					X						D119-646-041	REPLACEMENT STANDARD SKIDTUBE WITH WEARPADS
			1	1				X					D119-646-141	REPLACEMENT STANDARD SKIDTUBE WITH FULL LENGTH WEARPLATES & WEARPADS
									X				D119-646-151	WEARPLATE KIT STANDARD SKIDTUBE
					1	1				X			D119-646-241	REPLACEMENT STANDARD SKIDTUBE WITH TRAINING WEARPLATES
											X		D119-646-251	TRAINING WEARPLATES STANDARD SKIDTUBE
	1	1	1	1	1	1						X	D119-646-311	GROUND HANDLING KIT
1							1						D3887-041	STANDARD SKIDTUBE ASSY. WITH WEARPAD
20								1					D3887-043	STANDARD SKIDTUBE ASSY. WITH WEARPLATE & WEARPAD
26									1				D3847-043	FWD WEARPLATE ASSY
27									1				D3847-045	CENTER WEARPLATE ASSY
28									1				D3847-047	AFT WEARPLATE ASSY
29									5				D3847-1	WEARPAD
30									1				D3847-11	WEARPAD
31									30				AN3C5A	BOLT
32									30				AN960C10L	WASHER (OR NAS1149C0332R)
40										1			D3887-045	STANDARD SKIDTUBE ASSY. TRAINING WEARPLATE
44											1		D3849-041	FWD TRAINING WEARPLATE ASSY
45											1		D3849-043	AFT TRAINING WEARPLATE ASSY
51											16		D3904-1	WASHER
52											8		AN3C46A	BOLT
53											8		MS21043-3	NUT
60	2		2		2								D3883-1	SADDLE, OUTSIDE, LH
61		2		2		2							D3883-2	SADDLE, OUTSIDE, RH
62	2		2		2								D3884-1	SADDLE, INSIDE, LH
63		2		2		2							D3884-2	SADDLE, INSIDE, RH
64	16	16	16	16	16	16							D2652	BUSHING
65	8	8	8	8	8	8							AN3C50A	BOLT
66	12	12	12	12	12	12							AN4C6A	BOLT
67	8	8	8	8	8	8							MS21250-05006	BOLT
68	8	8	8	8	8	8							AN960C10L	WASHER (OR NAS1149C0332R)

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Revision: C

Date: 13.08.16

DART AEROSPACE USA, INC.

IIN-D119-646

Page 23 of 26

Item	Qty -011	Qty -012	Qty -111	Qty -112	Qty -211	Qty -212	Qty -041	Qty -141	Qty -151	Qty -241	Qty -251	Qty -311	Part Number	Description
69	24	24	24	24	24	24							AN960C416L	WASHER (OR NAS1149C0432R)
70	8	8	8	8	8	8							AN960C516L	WASHER (OR NAS1149C0532R)
71	8	8	8	8	8	8							MS21043-3	NUT
72	12	12	12	12	12	12							MS21043-4	NUT
73	12	12	12	12	12	12							D2712	SET SCREW
74	16	16	16	16	16	16							D3672-7	WASHER
75	24	24	24	24	24	24							D3672-3	WASHER
76	8	8	8	8	8	8							D3672-7	WASHER
80	1	1	1	1	1	1							D3407-041	TOW RING
81	2	2	2	2	2	2							D3417-5	WASHER
82	1	1	1	1	1	1							D3456-1	WASHER
83	1	1	1	1	1	1							MS21043-4	NUT
90												2	D3886-041	LUG ASSEMBLY
91												8	D2652	BUSHING
92												4	AN3C46A	BOLT
93												4	AN960C10L	WASHER (OR NAS1149C0332R)
94												4	MS21043-3	NUT

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Revision: **C**

Date: 13.08.16

Work Order ID 129040

129040

Page 1

Wednesday, January 28, 2015 8:55:22 AM

Item ID: D119-646-211

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 1/28/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/28/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS Date: 15-01-28 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D119-646	C								
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D119-646-211 CHG004								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
 46
 9-89
 MAR 19 2015
 (1x)
 DAS
 27
 9-89
 MAR 17 2015
 DAS
 28
 9-89
 (1x)
 MAR 19 2015

Work Order ID 129040***129040***

Page 2

Wednesday, January 28, 2015 8:55:22 AM

Item ID: D119-646-211

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 1/28/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/28/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-646-211

Location: _____

PPP rev: _____

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

Picklist Print

Wednesday, January 28, 2015 8:55:27 AM

Work Order ID: 129040

129040

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 1/28/2015

Required Date: 1/28/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: New issue DD verified by:EC
 12.09.12 as per ECN12-644 DD verf:JLM
 raise to chg003 (ECN 12-675) DD verf:JLM
 chg004 (ECN 13-534) DD verf:JLM
 14-628) DD verf:JLM
 IPP Rev:B
 IPP REV:C 12.11.05
 IPP REV:D 13.03.20 raise to
 IPP REV:E 14.11.25 IIN REV.C (ECN

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D119-646-241		Manufactured	No			110	Each	0.0000	1	1			
--------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D119-646-241

Replacement Skidtube with Run-on Landing Wearplates, Fits LH or RH

D119-646-311		Manufactured	No			110	Each	8.0000	1	1			
--------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D119-646-311

Ground Handling

Location	Loc Qty	Loc Code
----------	---------	----------

PK013	4	
124440	4	
PK13	4	
124441	4	

D3883-1		Manufactured	No			110	Each	8.0000	2	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3883-1

Saddle, Outboard LH

Location	Loc Qty	Loc Code
----------	---------	----------

ST404	8	
117615	2	
124452	6	

D3884-1		Manufactured	No			110	Each	6.0000	2	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3884-1

Saddle, Inboard LH

Location	Loc Qty	Loc Code
----------	---------	----------

ST404	6	
122514	2	
125107	4	

DAS
28
9-89

DAS
27
9-89

DAS
28
9-89
MAR 17 2015

DAS

MAR 17 2015

DAS
28
9-89

**

129414

Picklist Print

Wednesday, January 28, 2015 8:55:27 AM

Work Order ID: 129040

129040

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 1/28/2015

Required Date: 1/28/2015

Start Qty: 1.00

Required Qty: 1.00

D2652 Manufactured No 110 Each 274.0000 16 16

D2652

Bushing

**

MAR 17 2015

Location

Loc Qty

Loc Code

DAS
28
9-89

FG 45
31985 45
ST009 26
127633 26
ST012a 203
123711 32
124422 171

B12999

16

AN3C50A

Purchased No

110 Each 124.0000 8 8

AN3C50A

Bolt

**

MAR 17 2015

Location

Loc Qty

Loc Code

DAS
28
9-89

ST338a 24
M131367 24
ST346 100
M128491 16
M131263 84

8

AN4C6A

Purchased No

110 Each 362.0000 12 12

AN4C6A

Bolt

**

MAR 17 2015

Location

Loc Qty

Loc Code

DAS
28
9-89

FG 14
103344 4
121657 10
ST312A 200
m131320 200
ST345 148
m130716 148

12

Picklist Print

Wednesday, January 28, 2015 8:55:27 AM

Work Order ID: 129040

129040

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 1/28/2015

Required Date: 1/28/2015

Start Qty: 1.00

Required Qty: 1.00

MS21250-05-006

Purchased

No

110

Each

45.0000

8

8

MS21250-05-006

BOLT

**

DAS
27

MAR 17 2015

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

124291

10

ST273A

30

M131379

30

ST298

5

M129795

5

110

Each

4,921.000

8

8

NAS1149C0332R

Purchased

No

NAS1149C0332R

WASHER

**

DAS
27
9-89

MAR 17 2015

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

2178

m130325

2178

GA

18

125654

18

ST271

2725

125654

44

m130466

681

m131340

2000

110

Each

1,573.000

24

24

NAS1149C0432R

Purchased

No

NAS1149C0432R

WASHER

**

DAS
27

MAR 17 2015

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

1484

m125807

1484

ST271

89

m125807

89

Picklist Print

Wednesday, January 28, 2015 8:55:27 AM

Work Order ID: 129040

129040

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 1/28/2015

Required Date: 1/28/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0532R

Purchased

No

110

Each

295.0000

8

8

NAS1149C0532R

WASHER

**

27

MAR 17 2015

DAS
28
9-89

MS21043-3

Purchased

No

110

Each

1,285.000

8

8

MS21043-3

Nut

**

DAS
27
9-89

MAR 17 2015

DAS
28
9-89

MS21043-4

Purchased

No

110

Each

1,175.000

13

13

MS21043-4

Nut

**

DAS
27
9-89

MAR 17 2015

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

62

116513

62

ST271

233

m128537

233

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

179

m130673

179

GA

26

m130673

26

ST304

1000

m131340

1000

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

490

m128798

490

ST304

645

m128798

611

m128818

34

Picklist Print

Wednesday, January 28, 2015 8:55:27 AM

Work Order ID: 129040

129040

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 1/28/2015

Required Date: 1/28/2015

Start Qty: 1.00

Required Qty: 1.00

D2712

Manufactured No

110

Each

473.0000

12

12

DAS

27

MAR 17 2015

D2712

Set Screw

**

Location

Loc Qty

Loc Code

FG

55

29962

55

ST009

168

121858

4

124450

164

ST012a

250

127910

250

B11S1SS

D

DAS

28

9-89

DAS

27

9-89

MAR 17 2015

D3672-7

Manufactured No

110

Each

645.0000

24

24

**

D3672-7

Washer, Phenolic

Location

Loc Qty

Loc Code

FG

25

93370

25

ST055

90

120476

90

ST064A

530

124419

530

24

DAS
28
9-89

Picklist Print

Wednesday, January 28, 2015 8:55:27 AM

Work Order ID: 129040

129040

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 1/28/2015

Required Date: 1/28/2015

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

93.0000

1

1

**

DAS

27

9-89

FEB 12 2015

D3456-1

Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST040

86

121045

86

DAS

28

9-89

Work Order ID 129040

Wednesday, January 28, 2015 8:55:22 AM

129040

Page 1

Item ID: D119-646-211

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH with Run-on Landing Wearplates

Start Date: 1/28/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/28/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: *MLJ*Date: *1501-28* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

IIN-D119-646

C

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D119-646-211
CHG004

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

MLJ 1502-10

Work Order ID 117257

117257

Page 1

Thursday, May 01, 2014 10:28:10 AM

Item ID: D119-646-211

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube with Run-On Landing Wearplates LH

Start Date: 4/25/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/25/14 Req'd Qty: 1.00

1

Customer:

Reference: REWORK -NCR14-3771

Run Start *NR1*

Approvals: Process Plan:

Date: 14-05-01

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D119-646

B

100

Document Control

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile & type labels per PPP D119-646-211
CHG004

0.00

0.00

0.00

0.00

Memo

REMOVE FWD & AFT CAPS D2855-3
CLEAN ALL SIKAFLEX OFF CAPS & SCRP
IDENTIFY PER EACH TUBE CAPS
WAS REMOVED (PN & B)
wearplates - keep with B/A
AS PAR ECN RS1015
SCRP hardware

PULL FROM STOCK:
1 X D119-646-211 B113481
REWORK PER NCR14-3771

DART AEROSPACE		1270 ABERDEEN ST. HAWKESBURY, ON CANADA K6A 1K7 TEL.: 1-613-632-5200 www.dartaerospace.com	
PATENT	US #5735484 / CA #2222184 / EURO #0828655		
P/N	D119-646-211	CHG	CHG004
DESC.	Skidtube STD, LH	STC	SR02024SE
LOT	B113481	STC	
MODEL	Agusta A119/AW119MKII	STC	
TC APPROVAL # 09-89		MADE IN CANADA D2729-4	

101

101

HandFinish

Hand Finishing

P/O: 26625

Imt

CY 14/11/26 ①

Receive 1 x SD14-12-8